

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: 2016-84 Date Opened: 03 June 2016 Title: FabricationAircraft OEM: Eurocopter Aircraft Model: AS350/355 Product Type: Cargo Basket & Lid Product Model: XL Quantity: 5/5**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification  
Time Sheet (R&D)  
Notes

Initial or N/A

JC
N/A
JC
JC
N/A
N/A
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

JC
JC

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
94011	1	Body	JC
94012	1	Lid	JC
70405	4	Lid Walkway	JC
84262	2	Basket Handle Prov.	JC
84263	0	Lid Handle Provisions	JC
94023	1	Attachment Hoop	JC
94030	1	Hoop	JC

**Traveller**

Initial or N/A


**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

5/5
N/A
N/A
N/A

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Tracking (White) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

N/A
N/A
N/A
N/A
JC
N/A

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JR
N/A
N/A

Work performed by:

Print: D. BartfaiSign: [Signature]SCA: AD07Date: 27-Jul-16

ICC / Dual Inspection performed by:

Print: J. RekveSign: [Signature]SCA: AD01Date: 27-Jul-16

Work Order closed by:

Print: J. ClarkeSign: [Signature]SCA: AD02Date: 08-May-17

Approved Manufacturing Facility 73-04

Form 2010.03

Rev. Original 23 Sep 2014

# CARGO BASKET BODY FABRICATION - COMMON

Complete  
(initial or SCA #)

Work Order: 2016-84

AS350 XL X(5)

Date Open: 3 JUNE 2016

AD 73-04 07 AD 73-04 07 AD 73-04 07 AD 73-04 07 AD 73-04 07

## 1. Rim Assembly – Basket Body

- Cut and fit  $\frac{3}{4}$ " x 0.035 material to fit rim jig.
  - 1 or 2 lid prop bushing holes in short tube – refer to drawing
- Record material PO on attached material list.
- Remove writing on tubes with acetone and scotch bright.
- For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim.

## 2. Weld Rim Assembly.

- Record welding rod PO on attached material list.
- 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

## 3. Inspection

- Rim for complete welds

## 4. Frame assembly – body

- General
  - Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- Grind corner welds from step 2 on rim to allow hoops to sit flat.
- Pull required hoops from stock - standard, attachment, handle.
  - If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
  - Ensure vent hole is located at centre of tube to vent spine tubes.
- Assemble hoops with attachment lug locating jig and hoop spacing jig.
  - Ensure correct order and orientation of hoops. Refer to drawing.
    - Attachment lugs are on inboard side.
    - Handle bracket bushings are on outboard side, second hoop from both ends.  
May be on attachment hoops.
  - Run 3/8-24 tap into attachment lugs to ensure clear threads.
  - Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
  - Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
  - Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- Cut  $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- Cut  $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
  - Refer to applicable drawing for position, not required on some baskets.
- Option: Cut  $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- 90611 (R44) only: Cut  $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

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AD 73-04 05 AD 73-04 05 AD 73-04 05 AD 73-04 05 AD 73-04 05  
AD 73-04 07 AD 73-04 07 AD 73-04 07 AD 73-04 07 AD 73-04 07



- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
  - i. Extra large baskets
    - 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
    - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
    - 3. forward and aft hoops align to INSIDE of rim
  - ii. All other baskets
    - 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
    - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
    - 3. forward and aft hoops align to INSIDE of rim, except R44

## 5. TIG weld frame to rim assembly.

- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

## 6. Inspection

- a. Frame assembly for complete welds.

## 7. Mesh assembly.

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
  - i. For extra wide baskets only –
    - 1. Set  $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
    - 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
    - 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
  - ii. Using markings on table, align sheet to indicated edge.
  - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
  - iv. Bend mesh by hand tightly over tube along length of tube.
  - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
  - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.

	AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04	73-04
05	05	05	05	05	05
AD	AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04	73-04
07	07	07	07	07	07

- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
  - i. General
    - 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
    - 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
    - 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
    - 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
  - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
  - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
  - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
  - v. Clamp mesh to spine in at least 1 place per section.
  - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
  - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require ½ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
  - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
  - i. Remove surface rust with scotch-brite.
  - ii. Ensure mesh is cut at intersections where possible.
  - iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
  - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
  - i. Remove surface rust with scotch-brite.
  - ii. Ensure mesh is cut at intersections where possible.
  - iii. Bend top edge of mesh 1/4" down at 60 degrees.
  - iv. Fit mesh to front end of basket.



## CARGO BASKET BODY FABRICATION - COMMON

Complete

### 8. Weld mesh to frame assembly per drawing.

- a. Ensure lug locating jig is in place prior to welding.
- b. General welding requirements for all baskets, MIG welding:
  - i. Every intersection at top edges.
  - ii. Every intersection at ends.
  - iii. First 5 intersections down on hoops, then every second intersection.
  - iv. Every intersection along spine.
  - v. Extra large baskets – every intersection along corner.
  - vi. Every intersection around ends
  - vii. Every intersection along struts (if applicable)
- c. Bend and trim cells bent in to fit mesh as required and weld in position.
- d. Grind high spots off body mesh welds on ends before welding end mesh.
- e. 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
- f. Record welding rod PO on attached material list.

### 9. Weld basket components

- a. TIG weld lid prop bushing(s), one or two per drawing.
  - i. Record welding rod PO on attached material list.
  - ii. Record lip prop bushing WO on attached material list.
- b. TIG weld caps to close top of 1" hoops as applicable.
- c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
  - i. Cut inboard rim on aft end. Grind flush with hoops.
  - ii. TIG weld caps on open tubes.
  - iii. Record cap material PO on attached material list.
- d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
  - i. Record welding rod PO on attached material list.
  - ii. Record placard bracket WO on attached material list.

### 10. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- c. Drill #9 through lid prop bushing(s). De-burr hole(s).
- d. Remove surface rust with scotch-brite pad.

### 11. Final Inspection

To be completed by a different person than the previous steps.

- a. Basket body assembly for complete welds, and required minimum mesh weld locations.
- b. Filled vent holes – usually on hoops
- c. Overall condition and conformity to drawing(s).
  - i. Hoops for height.
  - ii. Rim for width and length and alignment.
  - iii. Lid prop lugs in correct ends.
  - iv. Fore/aft strut in hoop if required by drawing.
- d. Material lists complete.

## CARGO BASKET BODY FABRICATION - COMMON

Complete

(initial or SCA #)

- e. Tag complete basket body assembly in preparation for powder coating.

### 12. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag basket body assembly and place into stock in preparation for assembly.

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## CARGO BASKET BODY FABRICATION - COMMON

AS350 XL

2016-84

X(5)

### General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407** – Right side only

69811, Revision 3 – Standard Low Mounted Basket

94511, Revision 0 – Extra-Wide Low Mounted Basket

94611, Revision 0 – Extra-Wide Low Mounted Ski Basket

76611, Revision 0 – High Mounted Ski Basket

*Options* 70404, Revision 2 – Front end cutout – 698

70411, Revision 0 – Front end cutout – 945/946

#### **Eurocopter AS350/AS355** – left or right

77611, Revision 1 – Short Basket

76411, Revision 3 – Medium Basket (left or right)

78411, Revision 2 – Long Basket

→ 94011, Revision 0 – Extra Large (ski) Basket

*Options* 70406, Revision 2 – Front end cutout – 764/776/784/940

#### **Robinson R44** – left or right

90611, Revision 0 – Standard Basket (left or right)

#### **Bell 206B** – right side only

80211, Revision 0 – Short Basket

80311, Revision 0 – Medium Basket

81111, Revision 0 – Long Basket

*Options* 70406, Revision 2 – Front end cutout – 802/803/811

#### **Bell 429** – right or left

95911, Revision 0 – Standard Basket

#### **Bell Medium** – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

*Options* 70407, Revision 1 – Front end cutout – 751

704, Revision – Front end cutout – 955

#### **MD600**

82811, Revision 0 – Standard Basket

#### **Options** – Applicable to all models

70403, Revision 5 – Auxiliary Latch



Work Order: 2016-84Date Opened: 3 JUNE 2016

Material Tracking Sheet  
Eurocopter AS350 / AS355  
Extra Large Basket Body Fabrication

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>15</u>	94011	94011-01	<b>Basket Assembly</b>		
<b>Step 1</b>	<u>ORM</u>			<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>15072</u>
	. 2		--	3/4" Tube - Short Rim (25.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>15072</u> <u>14099</u> <u>15072</u>
	. 1		--	3/4" Tube - Long Stringer (95.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>15072</u>
	. 4		--	3/4" Tube - Short Stringer (2.25")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>14099</u>
<b>Step 2</b>				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>14005</u>
<b>Step 3</b>				<i>Inspection - Rim</i>	None	
<b>Step 4</b>				<i>Frame Assembly</i>		
	. 4		94030-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>15072</u>
	. 2		94023-01	Hoop - attachment		<u>16002</u> <u>16037</u>
	. 5		--	1/2" Tube - spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>15072</u>
<b>Step 4.g.</b>		70406	70406-01	<i>Option: Front End Cutout</i>		
			70406-03	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	
			70406-04	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	
<b>Step 5</b>				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>14005</u>
<b>Step 6</b>				<i>Inspection - Frame Assembly</i>	None	
<b>Step 7</b>				<i>Mesh Assembly</i>		
	. 1		--	Mesh (Body - 56" x 96")	3/4-16F Expanded Mild Steel sheet	<u>16009</u>
	. 2		--	Mesh (End - 25" x 18")	3/4-16F Expanded Mild Steel sheet	<u>16009</u>



Work Order: 2016-84Date Opened: 3 JUNE 2016Material Tracking Sheet  
Eurocopter AS350 / AS355  
Extra Large Basket Body Fabrication

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
<b>Step 8</b>				<i>Weld Mesh</i>		
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	15059
<b>Step 9</b>				<i>Weld Basket Components</i>		
	. 2		49215-01	Spacer (Lid prop)	304 Stainless Steel, ½" Dia.	2015-84
	. A/R		--	Welding Rod	ER308L TIG Rod	14028
<b>Step 10</b>				<i>Clean Up</i>	None	
<b>Step 11</b>				<i>Inspection - Final Assembly</i>	None	
<b>Step 12</b>				Powder Coating		16045/16047/16055 (1) (3) (1)

## CARGO BASKET LID FABRICATION

AS 350 XL Lid x 5

Complete  
(initial or SCA #)Work Order: 2016-84Date Open: 3 JUNE 2016

## 1. Rim Assembly – Basket Lid

- Cut and fit  $\frac{3}{4}$ " x 0.035 material to fit rim jig, 45 degree ends.
  - 1 or 2 lid prop bushing holes in short tube – refer to drawing
- Record material PO on attached material list.
- Remove writing on tubes with acetone and scotch bright.

## 2. Weld Rim Assembly

- Record welding rod PO on attached material list.

## 3. Inspection

- Rim for complete welds

## 4. Frame assembly – Lid

- General

- Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)

- Insert rim from step 2 into jig.
- Cut and fit  $\frac{3}{4}$ " x 0.035 material, 21" long, for lid cross members.
- Record material PO on attached material list.
- Remove writing on tubes with acetone and scotch bright.
- Drill vent holes into rim to vent cross members into rim.
- Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.

## 5. Frame assembly – Lid with optional walkway modification

- Fit cross members to rim in accordance with step 4.
- Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
- Cut  $\frac{1}{2}$ " x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
- Drill vent holes into cross members at walkway stringers.
- Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.

## 6. Weld frame assembly.

- Record welding rod PO on attached material list.
- Jigs must remain in place for as long as practical during welding.

## 7. Inspection

- Frame assembly for complete welds.



# CARGO BASKET LID FABRICATION

## 8. Mesh assembly.

Note: 95912 (Bell 429) does not have mesh. Skip to step 10.

- Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- Cut mesh to size for lid.
- Remove surface rust with scotch-brite.
- Ensure lid is prepared for mesh on the correct side.

## 9. Weld mesh to frame assembly per drawing.

- General welding requirements for all lids:
  - Every intersection on all edges.
  - First 5 intersections along cross members, then every second intersection.
- MIG weld both short sides.
- Clamp lid over spacer at centre of lid to pre-tension mesh.
  - $\frac{3}{4}$ " for lids under 76"
  - 1" (check) for lids over 76"
- Weld remainder of mesh as indicated in a.
- Record welding rod PO on attached material list.

## 10. Weld lid components.

- Handle brackets, locate in accordance with drawing.
  - Standard location:  $\frac{1}{4}$ " outside of last cross member on both ends.
  - Record handle bracket WO and welding rod PO on attached material list.
- Lid prop bushing(s).
  - one or two in accordance with drawing.
  - Record lid prop bushing WO and welding rod PO on attached material list.
- Placard bracket. – not installed on 95912 (Bell 429)
  - Locate on cross member to set bracket in centre bay of lid.
  - Record placard bracket WO and welding rod PO on attached material list.

## 11. Clean up

- Grind high spots off mesh welds.
- Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
- Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
- Drill #9 through lid prop bushing(s). De-burr hole(s).
- Drill for lid bumpers using  $\frac{1}{4}$ " (#3) centre drill.
  - 3 places for lids under 76"
  - 4 places for lids over 76"
- Remove surface rust with scotch-brite pad.

## 12. Final Inspection

To be completed by a different person than the previous steps.

- Basket lid assembly for complete welds, and required minimum mesh weld locations.
- Material lists complete.
- Overall condition and conformity to drawing(s).

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AD 73-04 07

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## CARGO BASKET LID FABRICATION

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73-04  
02

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AD Complete  
(initial or SCA #)  
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~~02~~ 73-04  
02

### 13. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag lid assembly and place into stock in preparation for assembly.



## **CARGO BASKET LID FABRICATION - COMMON**

AS350 xL  
w/w

### **General**

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407 – Right side only**

69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket

94612, Revision 0 – Extra-Wide Low Mounted Ski Basket

76612, Revision 0 – High Mounted Ski Basket

#### **Eurocopter AS350/AS355 – left or right**

77612, Revision 1 – Short Basket

69812, Revision 3 – Medium Basket (left and right)

78412, Revision 2 – Long Basket

→ 94012, Revision 0 – Extra Large (ski) Basket

#### **Robinson R44 – left or right**

90612, Revision 0 – Standard Basket (left or right)

#### **Bell 206B – right side only**

80212, Revision 0 – Short Basket

80312, Revision 0 – Medium Basket

81112, Revision 0 – Long Basket

#### **Bell 429 – right or left**

95912, Revision 0 – Standard Basket

#### **Bell Medium – left or right**

75112, Revision 0 – Standard Basket

95512, Revision 0 – Extra Large (ski) Basket

#### **MD600**

82812, Revision 0 – Standard Basket

#### **Options**

→ 70405, Revision 3 – Walkway

70402, Revision 1 – Lid Door

Work Order: 2016-84

Material Tracking Sheet  
Eurocopter AS350 / AS355  
Extra Large Lid Fabrication

1 of 2

Date Opened: 3 JUNE 2016

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<sup>DRM</sup> <b>x5</b>	94012	<b>94012-01</b>	<b>Lid Assembly</b>		
<b>Step 1</b>				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, 3/4" x 0.035 Sqr. Tube	15072
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	15072
<b>Step 2</b>				<i>Weld Rim Assembly</i>		
	. A/R			Welding Rod	ER70S-2 TIG Rod	14005
<b>Step 3</b>				<i>Inspection - Rim</i>	None	
<b>Step 4</b>				<i>Frame Assembly</i>		
	. 4		--	3/4" Tube - Cross Member (21")	4130 Steel, 3/4" x 0.035 Sqr. Tube	15072
<b>Step 5</b>		70405		<i>Option: Frame Assembly - with walkway</i>		
	. 10		--	1/2" Tube - walkway	4130 Steel, 1/2" x 0.035 Sqr. Tube	15072
<b>Step 6</b>				<i>Weld Frame Assembly</i>		
	. A/R			Welding Rod	ER70S-2 TIG Rod	14005
<b>Step 7</b>				<i>Inspection - Frame Assembly</i>	None	
<b>Step 8</b>				<i>Mesh Assembly</i>		
	. 1		--	Mesh (lid - 96" x 22")	3/4-16F Expanded Mild Steel sheet	16038
<b>Step 9</b>				<i>Weld Mesh</i>		
	. A/R			Welding Rod	ER70S-6 MIG Wire	15059

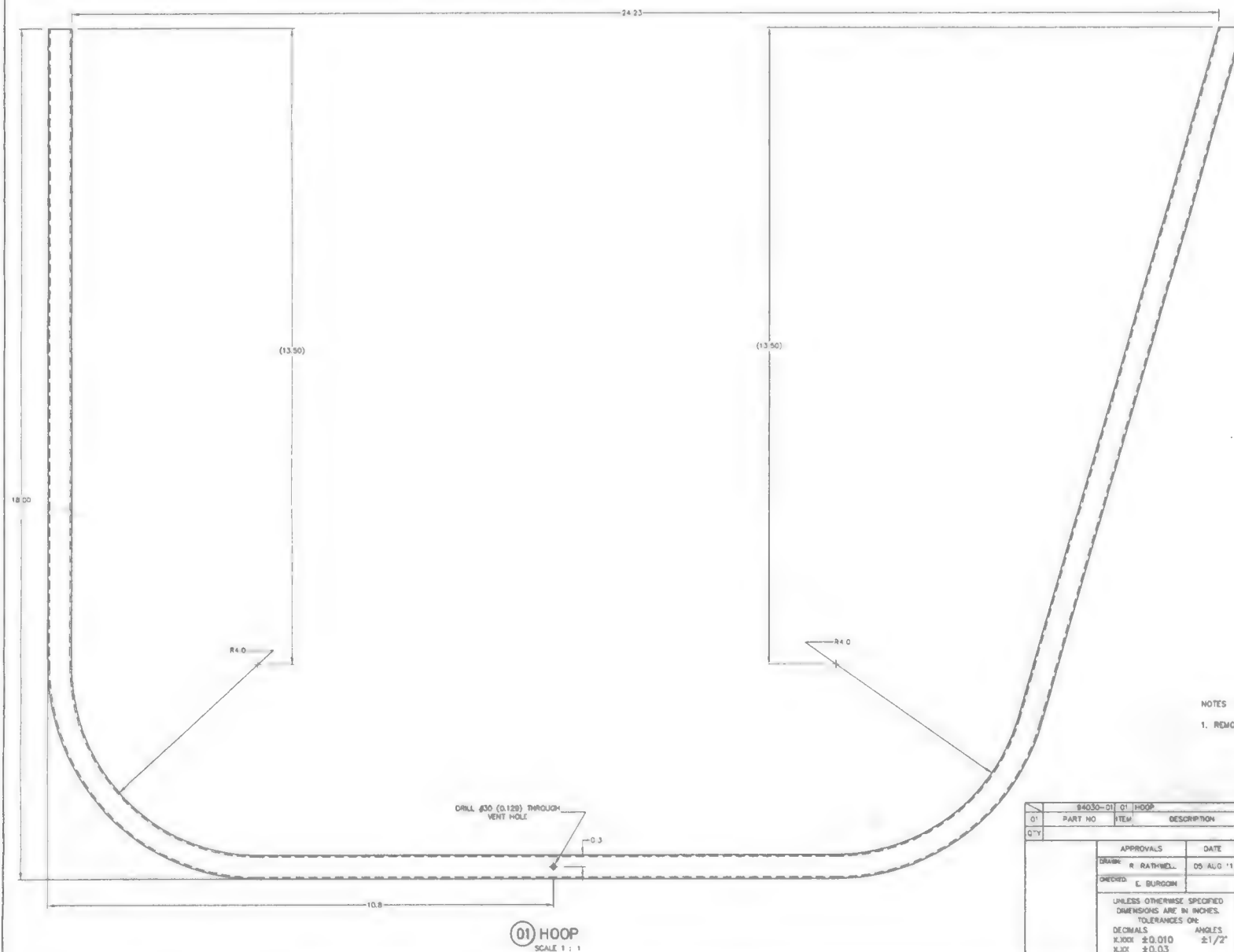


Work Order: 2016-84Date Opened: 3 JUNE 2016Material Tracking Sheet  
Eurocopter AS350 / AS355  
Extra Large Lid Fabrication

2 of 2


Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
<b>Step 10</b>				<i>Weld Lid Components</i>		
	. 1	84262	84262-01	Upper Handle Bracket Assembly		2016-54
	. . 4		36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	
	. . 2		36275-02	Support	304 Stainless, 5/16" Rod	
	. A/R			Welding Rod	ER308L TIG Rod	14028
	. 2		49216-01	Spacer (Lid prop)	304 Stainless, 1/2" Dia.	2015-84
	. A/R			Welding Rod	ER308L TIG Rod	14028
	. 1		36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	15061
	. A/R			Welding Rod	ER70S-2 TIG Rod	14005
<b>Step 11</b>				<i>Clean Up</i>		
<b>Step 12</b>				<i>Inspection - Final Assembly</i>		
<b>Step 13</b>				Powder Coating		16045/16047/16055 (1) (3) (1)

<p>THE FOLLOWING INFORMATION IS BEING MADE AVAILABLE TO THE PUBLIC BY THE NATIONAL ARCHIVES. THE DRAMING OF ANY PORTION HEREOF MAY BE REPRODUCED, COPIED, OR PUBLISHED IN ANY MANNER WITHOUT CHARGE FOR MANUFACTURING OR DISTRIBUTION OF THE WRITTEN CONTENT OF THIS ACTION, IF BY ACCEPTING THIS DRAMING FOR REPRODUCTION, THE REPRODUCER AGREES TO HOLD ADOPTED FROM THE USE OF MATERIAL OF THIS DRAMING OF THE INFORMATION CONTAINED HEREIN.</p>			
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; DRAWING REFORMATTED TO A1	BJC	11/07/2014



## NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

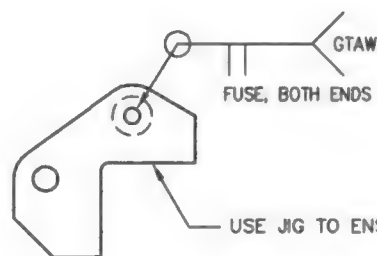
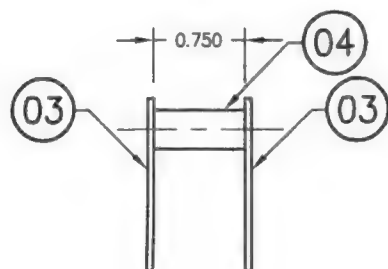
B4303-01		Q1	HOOP	4130 STEEL COMD N	MS-1-4736	0.5 X 0.035 SQD TUBE
Q1	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
LIST OF MATERIALS						
APPROVALS			DATE			
DRAWN: R. RATHIEL			05 AUG '11			
CHECKED: C. BURDICH						
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE:			 <b>AERO DESIGN LTD.</b> 9999A MALAYSIA ROAD PORTER ELEV. BC, CANADA, T8A 0G3 TEL: 804-868-8978 <a href="http://www.aerodesign.ca">www.aerodesign.ca</a>			
DECIMALS                      ANGLES X.XXXX                      ±0.010                      ±1/2" X.XX                      ±0.03 X.X                      ±0.1			<b>EUROCRYPTER AS350 &amp; AS355 SERIES</b> <b>QUICK RELEASE CARGO BASKET</b> <b>HOOP</b>			
SCALE: 1" = 1'				SIZE: <b>A1</b>	QTY: <b>40</b>	REV: <b>1</b>
SHEET: 1 OF 1						



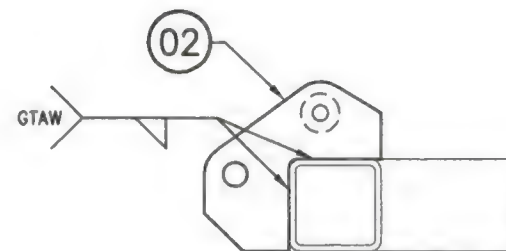
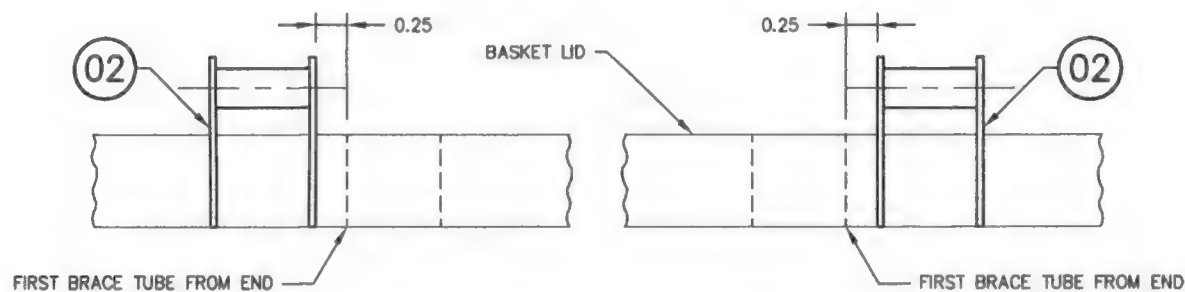
2016-84

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 84262 REV. 1	BJC	14/02/2014



## 02 HANDLE BRACKET ASSEMBLY



## 01 LID HANDLE PROVISIONS ASSEMBLY

### NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ROD CONFORMING TO ER308L OR EQUIVALENT.

1		36275-02	04	SUPPORT
2		36273-01	03	LID BRACKET
	2	84263-02	02	HANDLE BRACKET ASSEMBLY
		84263-01	01	LID HANDLE PROVISIONS ASSY
02	01	PART NO.	ITEM	DESCRIPTION
QTY	QTY	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	14 FEB 2014
CHECKED: JASON REKVE	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX ±0.010 ±1/2°  
X.XX ±0.03  
X.X ±0.1



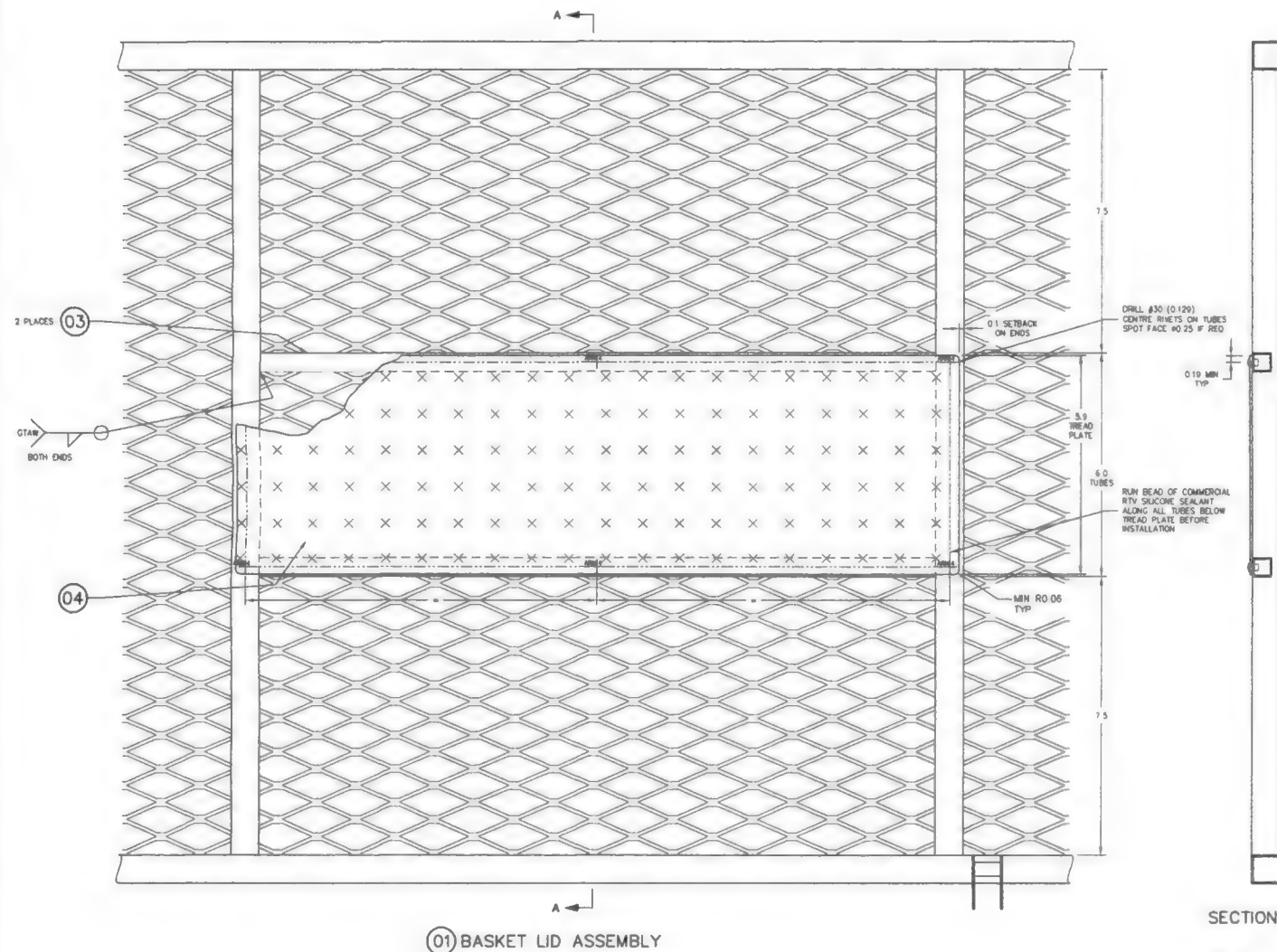
**AERO DESIGN LTD.**

9888A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 804.408.8378 www.aerodesign.ca

HELICOPTER CARGO BASKET  
LID HANDLE PROVISIONS ASSEMBLY

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84263	0

2016-84



SECTION A-A

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCOPTER EC135, MCCONNELL DOUGLAS MD500, BELL 206B BASKETS	BJC	DEC 4/08
3	ADD NEW AS350 AND 206L/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED, MODEL LIST REMOVED, ADD ALT. RIVET, ADD NOTE 7	BJC	29/03/2014

## NOTES:

- THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LD. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LD. REMAINDER OF LD ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
- TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
- REMOVE ALL BURRS AND BREAK SHARP EDGES.
- WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2888C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
- WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
- THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
- WIDTH AND POSITION OF LD STEP MAY BE ADJUSTED TO MATCH LD DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LD.

A/R	CR3213-4-02	BLIND RIVET	ALTERNATE HR3213-4-02			
1	70405-04 04	TREAD PLATE	ALUMINUM	COMMERCIAL	0.063 TREAD PLATE	
2	70405-03 03	TUBE	4130 STEEL COND. N	MIL-T-6736	0.5 X 0.035 WALL TUBE	
1	SEE NOTE 1:02	BASKET LID ASSEMBLY				
1	70405-01 01	BASKET LID ASSEMBLY - MODIFIED WITH STEP				
D1	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

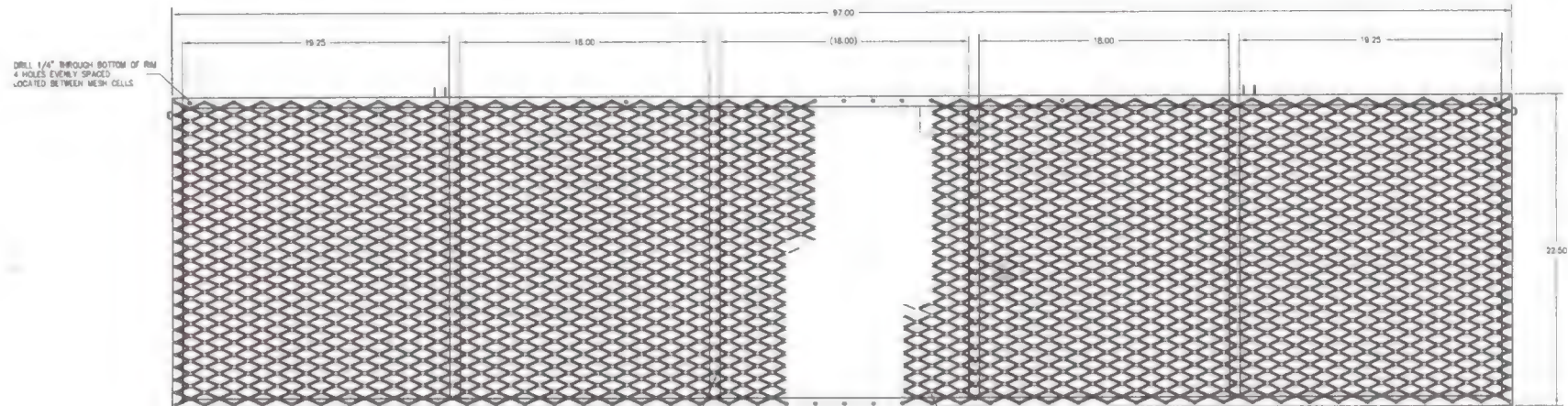
BASIC CODE REF: HAS 523	DASH NO. FOR DIAMETER H=HFD HEAD NEAR SIDE F=HFD HEAD FAR SIDE	DASH NO. FOR LENGTH	APPROVALS DRAWN: JEFF CLARKE 21 SEPT 2008 CHECKED: E. BURGON	DATE	 <b>AERO DESIGN LTD.</b> 8888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.480.3818 www.aerodesign.ca
C=COUNTERSUNK D=DIMPLE DIGIT# OF SHEETS TO BE DIMPLED	DASH NO. FOR LENGTH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1	CARGO BASKET LD STEP MODIFICATION		
BASIC CODES: BJ=MS20470AD BB=MS20426AD ARH=CR3213 ARM=CR3212	+ INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET	SCALE 1:15 SHEET 1 OF 1		DWG NO. <b>A1 70405</b>	REV <b>4</b>

[illegible]



2016-84

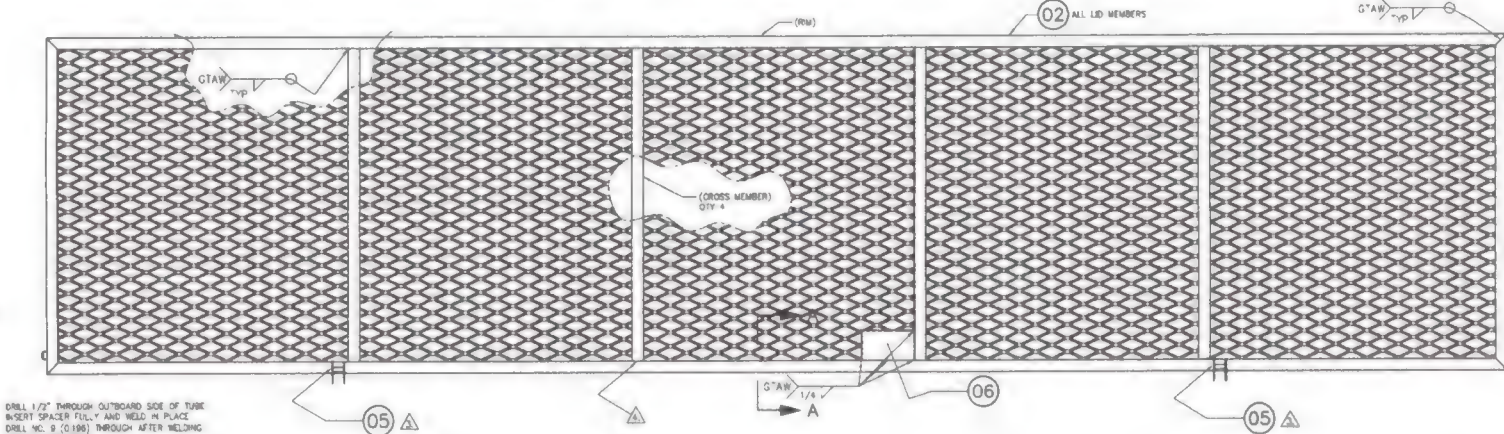
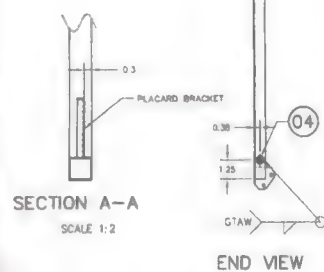
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; CHANGED 38273-01 TO 84263-01. ITEM #5 ADDED	BJC	10/07/2014
	WELDING ROD UPDATED; # OF WELDS DOWN BRACE TUBES INCREASED		



GTAW TYP  
ATTACHMENT OF MESH TO RIM  
WELD EACH INTERSECTION

GTAW TYP  
ATTACHMENT OF MESH TO CROSS MEMBERS  
WELD FIRST FIVE INTERSECTIONS  
THEN EVERY SECOND INTERSECTION  
ADDITIONAL WELDS ARE PERMITTED AS REQUIRED

BOTTOM VIEW (03) MESH



TOP VIEW

(01) LID ASSEMBLY

- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
  2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS 2885C.
  - 4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
  - STAINLESS AND 4130 STEEL: WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
  3. INSTALL ITEM 5 (LID HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD DRAWING 84263.
  4. DRILL #30 (0.125) HOLES IN LOW TUBE MEMBERS AT BRACE LOCATIONS TO VENT WELD GASSES WHEN ASSEMBLY IS COMPLETE. FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
  5. FINISH THOROUGHLY CLEAN AND POWDER COAT LID ASSEMBLY.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	38204-10	06	PLACARD BRACKET			
1	84263-01	01	LID HANDLE PROVISIONS ASSEMBLY			
1	48216-01	04	SPACER			
A/R	3/4 - 18"	03	W-54	MILD STEEL	COMMERCIAL	
A/R		02	SQUARE TUBE	4130 STEEL, COND N	ML-T-6756	0.75 X 0.035 SQR TUBE
1	94012-01	01	LID ASSEMBLY			

APPROVALS	DATE
DRAWN: R. RATHMEL	05 AUG 11
CHECKED: E. BURGMAN	

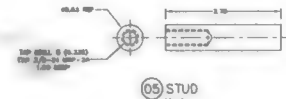
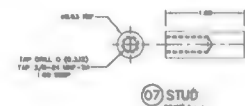
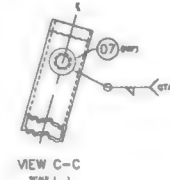
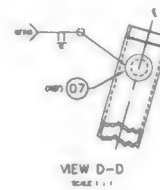
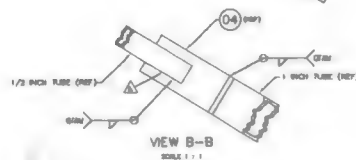
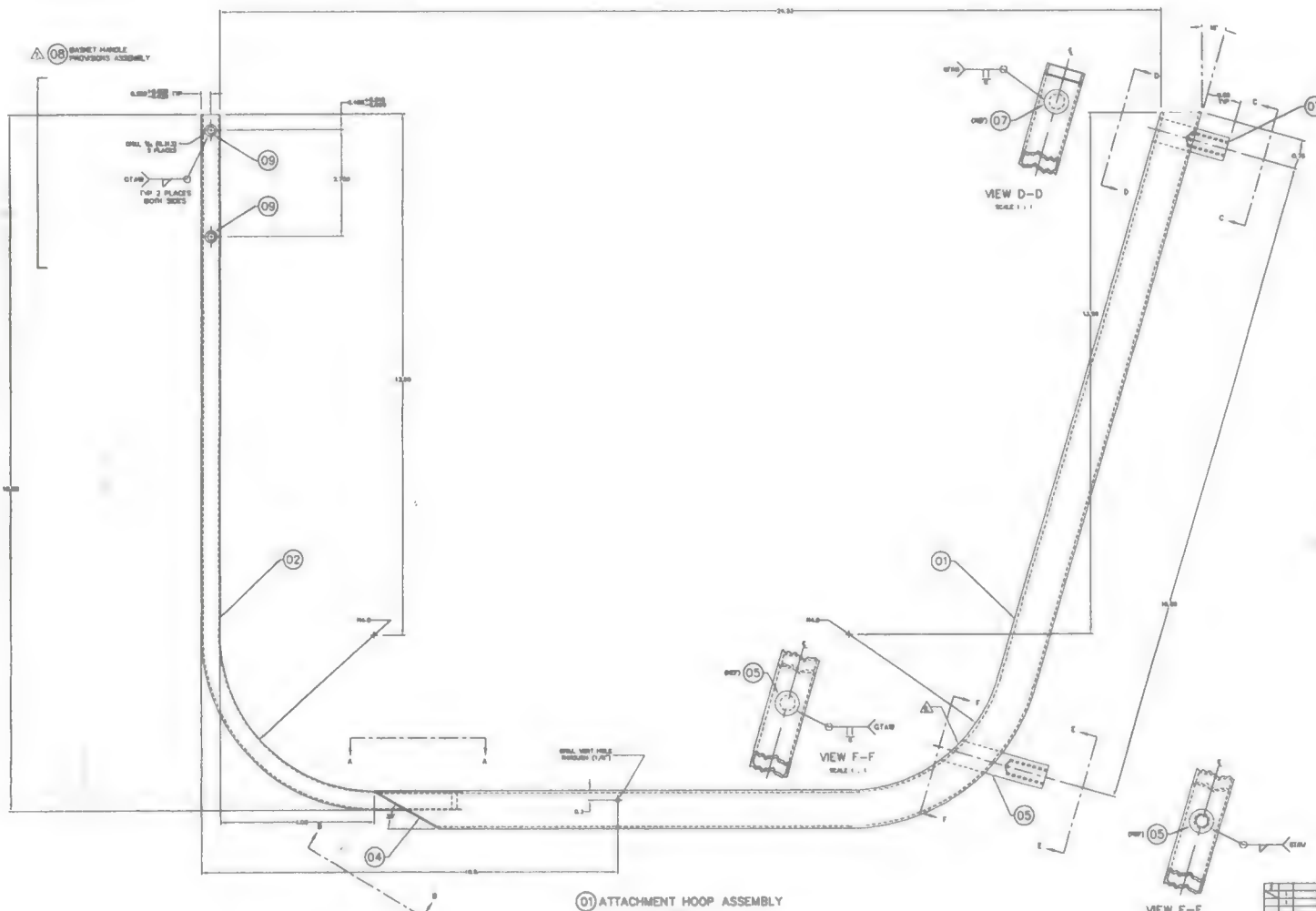
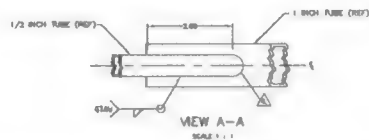
**AERO DESIGN LTD.**  
9008A MALASPINA ROAD  
POWELL RIVER, BC, CANADA V8A 0G5  
TEL: 250-403-8876 www.aerodesign.ca

**EUROCOPTER AS350 & AS355 SERIES  
QUICK RELEASE CARGO BASKET  
LID ASSEMBLY (EXTRA LARGE)**

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS: ±0.010  
ANGLES: ±1/2°  
X.XX: ±0.03  
X.X: ±0.1

SCALE: 1:4  
SHEET 1 OF 1  
A1 94012 1

2016-54



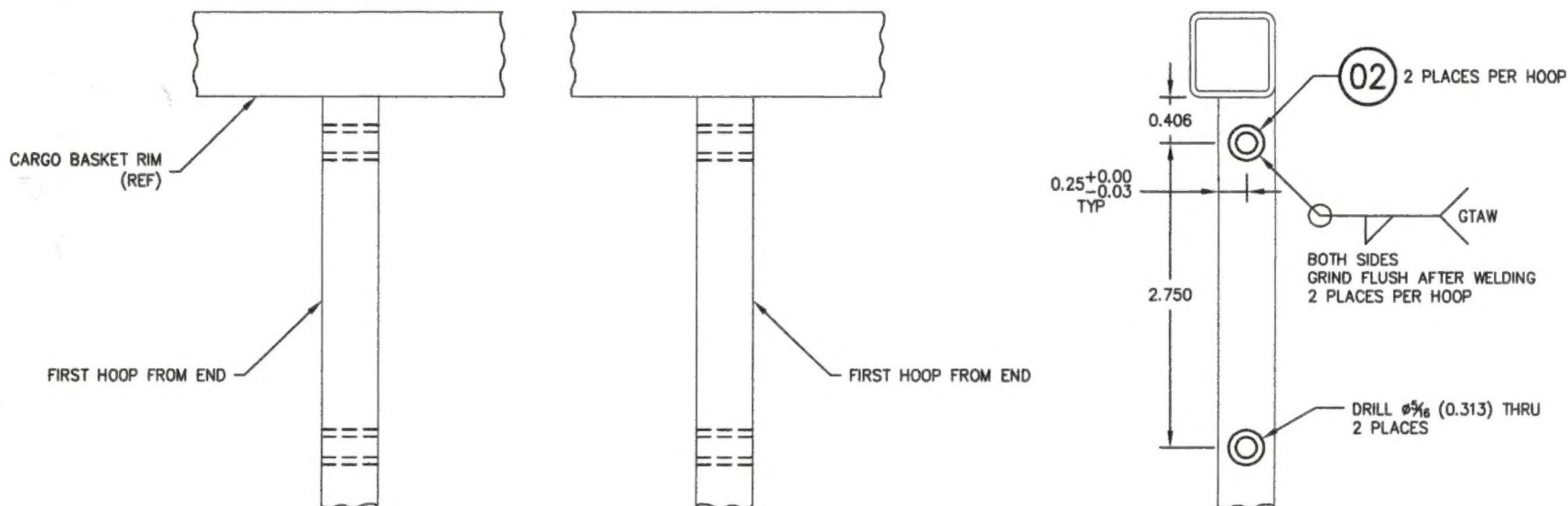
- NOTES
1. FINISH ALL SURFACES AND BREAK SHARP EDGES.
  2. (DIMENSIONS)
  3. WELDING OF 4130 STEEL TO BE COMPLETED BY STAINLESS STEEL TO ASSURE WELDING AND SHALL CONFORM TO AWS D10.1-1 OF EQUIVALENT.
  4. HALL SLOT (05) 1" FLANGE AS SHOWN. CENTER LINE OF 1/2" TUBE TO REMAIN CAP BETWEEN 1" FLANGE AND 1/2" TUBE.
  5. HATCHET HANDLE OF CAP (04) (05) TO FIT AS REQUIRED.
  6. CUT AWAY PORTION OF STUD (04) (05) FLUSH TO EXPOSE SURFACE OF 1" TUBE AS SHOWN.
  7. HATCHET HANDLE PROVISIONS ARE INSTALLED IN ACCORDANCE WITH HATCHET HANDLE DRAWING 0401. DIMENSIONS AND PARTS SHOWN ARE FOR REFERENCE ONLY.

REV	DATE	DESCRIPTION	BY	CHKD	APP'D
1	10/15/88	DESIGN	W. J. B.	W. J. B.	W. J. B.
2	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
3	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
4	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
5	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
6	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
7	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
8	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
9	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
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11	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
12	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
13	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
14	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
15	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
16	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
17	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
18	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
19	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
20	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
21	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
22	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
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24	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
25	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
26	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
27	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
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29	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
30	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
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32	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
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58	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
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60	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
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73	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
74	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
75	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
76	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
77	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
78	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
79	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
80	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
81	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
82	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
83	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
84	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
85	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
86	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
87	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
88	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
89	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
90	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
91	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
92	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
93	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
94	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
95	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
96	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
97	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
98	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
99	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.
100	10/15/88	REVISED	W. J. B.	W. J. B.	W. J. B.

**AERO DESIGN LTD.**  
 1000 WILSON AVENUE  
 FORT WORTH, TEXAS 76102  
 (817) 342-1111  
 FAX (817) 342-1112  
 EUROCOPTER AS350 & AS355 SERIES  
 QUICK RELEASE CARGO BASKET  
 ATTACHMENT HOOP ASSEMBLY  
 SCALE 1 : 1  
 SHEET 1 OF 1  
 A0 94023 1

2d6-84

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36262	BJC	03/11/2009
1	CHANGE LOCATION OF BUSHINGS	BJC	29/09/2011
2	UPDATED TITLE BLOCK, MOVE LID PROVISIONS TO 84263	BJC	14/02/2014



# 01 BASKET HANDLE PROVISIONS ASSEMBLY PROVISIONS TO BE INSTALLED IN HOOPS BEFORE ASSEMBLY TO BASKET RIM

## NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ROD CONFORMING TO ER70S-2 OR EQUIVALENT.

4	84272-01	02	BUSHING
	84262-01	01	BASKET HANDLE PROV. ASSY
01	PART NO.	ITEM	DESCRIPTION
QTY	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX ±0.010 ±1/2°  
X.XX ±0.03  
X.X ±0.1



**AERO DESIGN LTD.**

9888A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 804.488.8376 www.aerodesign.ca

HELICOPTER CARGO BASKET  
BASKET HANDLE PROVISIONS ASSEMBLY

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84262	2





# Aero Design Ltd.

AMF 73-04

9888 A Malaspina Rd.

Powell River, BC

Canada

V8A 0G3

XL Sk1

## Complete Fabrication Instructions

This sheet is designed to assist in the fabrication of Aero Design products in accordance with the company Manufacturing Policy Manual, the Canadian Aviation Regulations and other applicable technical documentation.

#####

Nomenclature: AS350 Quick Release Cargo Basket Hoop Work Order #: 2016-84

Number of Units: 4

Model	Requirements	Reference	Initial				
AS350	Review LOEP to ensure most current technical specifications	N/A	DB	DB	DB	DB	DB
AS350	Cut a piece of material to <del>52 7/8"</del> <sup>53 1/8"</sup> <del>53 1/8"</del> <sup>52 15/16"</sup>	N/A	DB	DB	DB	DB	DB
AS350	Cut one end at 90 degrees and the opposite end at 16 degrees.	N/A	DB	DB	DB	DB	DB
AS350	At the 90 degree end measure 13 <sup>2/8"</sup> and mark. Bend at that mark <u>Set stop @ 103° 5/16</u>	N/A	DB	DB	DB	DB	DB
AS350	At the longest point of the 16 degree end measure 15 <sup>3/16"</sup> and mark. Bend at that mark. <u>Set stop @ 85° 5/16</u>	N/A	DB	DB	DB	DB	DB

### Post Fabrication Inspection

Inspect components to ensure conformity to the applicable design data.

Signature: [Signature]  
Licence Number or SCA: AD07  
Date: June 3rd/2016 DB June 3rd/2016

2016-84

# 1" Hoop Bend

## Requirements

\*Review LOED to ensure most up to date specifications.

\* Cut ~~33 3/8~~ <sup>DB</sup>  $33\frac{1}{2}$  Long to long

\*Cut one end at 16 degrees and the other at 60 degrees.

\* At the 16 degree end measure up  $21\frac{1}{8}$  and mark

\* Line up the mark on the radius of the bender and bend

\* Lower stop to 101 degree ✓ DB

From ~~the~~ long end  
of ~~the~~ 16° bend

~~33 3/8~~  
~~21 1/8~~  
 $33\frac{1}{2}$   
 $21\frac{1}{8}$

~~21 1/8~~

Work Order: 2016-84Date Opened: 3 June 2016

Material Tracking Sheet  
Eurocopter AS350 / AS355  
Extra Large Hoops Fabrication

1 of 1

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<del>16</del> 10 pk.		94030-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	15072
	<del>28</del> 10 pk.		94023-01	Hoop - attachment		
Step 1				1/2 Hoop Fabrication - 1/2" hoop		
	. 1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	15072
Step 2				Machining	None	
Step 3				1/2 Hoop Fabrication - 1" hoop		
	. 1		--	1" tube - hoop	4130 Steel, 1" x 0.065 Sqr. Tube	16002/16037
Step 4				Machining	None	
Step 5				Joint Preparation	None	
				Welding		
Step 6	. 1		94023-05	Stud	1018 Mild Steel, 5/8" Dia.	2015-108
	. 1		94023-07	Stud	1018 Mild Steel, 5/8" Dia.	2015-108
Step 7	. 2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	15024
Step 8	. 1		76423-04	Cap	1018 Mild Steel, 0.050" Sheet	15035
	. A/R		--	Welding Rod	ER70S-2	14005
Step 9				Finishing and Inspection	None	